User:

Tuesday, 1/9/2007 4:07:44 PM

Kim Johnston

## **Process Sheet**

SPLIT-1

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 30220

**Estimate Number** 

: 10993

P.O. Number

: NA

This Issue

First Issue

Previous Run

: 1/9/2007

Prsht Rev

: MIM : 29603

S.O. No. : HIR

Type

: MACHINED PARTS

Written By Checked & Approved By

Comment

Now turned on Cobra NG

Part Number **Drawing Number** 

**Drawing Name** 

: D2579 : D2579 REV D

: CROSSBOLT SPACER

: N/A Project Number

: D Drawing Revision : NIA

Material Due Date : 1/22/2007

Qty:

40

Each 500 Um:

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

6061-T6 Tube .500 x.058W

M6061T6T0500W058

Comment: Qty.: 0.3762 f(s)/Unit Total: 188.1075 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6 ) or 5052-H32 (WW-T-700/4)

0.500 Dia x 0.058 Wall

Batch 103646 HARDINGE CNC LATHE SMALL

07-05-7

2.0

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA245

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

4.0

3.0

QC8

Comment: SECOND CHECK

PACKAGING 1 5.0

PACKAGING RESOURCE #1

7.03.07

40

40

-10

-10

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 4

BF 07-03-07 40

## **Dart Aerospace Ltd**

W/O: WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							78.4
Part No	):	PAR #: Fault Category:	NCR: Yes	No DQ	A: 🗲	Date:	7/63/08

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		V V	VORK ORD	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B			Annound	Approval
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Chief Eng Date		Verification Section C	Approval Chief Eng	QC Inspector	
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	- 性語科							
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8	100							

NOTE: Date & initial all entries

Tuesday, 1/9/2007 4:07:45 PM ; er:

Kim Johnston

Drawing Name: CROSSBOLT SPACER

Job Number: 30220

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Customer: CU-DAR001 Dart Helicopters Services

Description;

6.0

FINAL INSPECTION/W/O RELEASE

**Process Sheet** 



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U of Box

## Dart Aerospace Ltd

W/O: DATE STEP			HANGES	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector	
					NE T		, rod mgr	
				1				41
Part No	•	PAR #	: Fault Category:	NCR: Yes	No DQA		Date:	

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:

		Description of NC		Corrective Action Section E	3	Verification	Annroyal	Anneous
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30220		
Description: Cross Bolt Spacer	Part Number:	D2579		
Inspection Dwg: D2579 Rev: D		Page 1 of 1		

## FIRST ARTICLE INSPECTION CHECKLIST

		X First Art	cle	Prot	totype		45
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of		mments
4.070	+/-0.030	468					
0.058	+/-0.010	C6C	./				
	A-1100						
	115						
		Audited by:	Er	F	Prototype Ap	=1	N/A
Date:	107-7	Date:	67/03/0	7		Date:	
v Date	Change					Revised by	Appro

Dart Ae	rospace Li	td								
W/O:			WC	RK ORDER CH	ANGES					
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										4
Part No		PAR #:	Fault Cate	jory:	NCF	R: Yes N	lo DQ/	۸:	_ Date: _	
						QA: N/	C Closed	d:	_ Date: _	
NCR:		V	VORK ORDE	R NON-CONFO	RMANCE	(NCR)	<u> </u>		25	
		Description of NC	Description of NC Corrective Action Section				Verific	ication Approve	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Section		Chief Eng	QC Inspector
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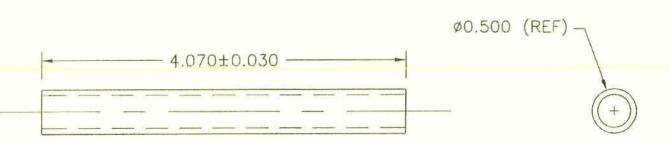
NOTE: Date & initial all entries





DESIGN	ORAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROYED	DRAWING NO. REV. D
45	1 HE	D2579 SHEET 1 OF 1
DATE		TITLE SCALE
99.05.19		CROSS BOLT SPACER 1:1
A	96.09.16	NEW ISSUE
В	96.12.05	0.065 WALL WAS 0.035 WALL
С	97.02.21	0.058 WALL WAS 0.065 WALL
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)





MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4) 0.500 DIA x 0.058 WALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED